



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4091-1
Job Sheet 192787



Part No: D4091-1

Job Qty: 50 pcs

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/2/19

Job Tracking No:

Due Date: 4/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: Dwg D4091 Rev. A IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Workcenter / Supplier Lead Time	Sign-off
100	Purchasing	50 pcs	4/26/19	4/26/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	50 pcs	4/26/19	4/26/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S174252



Part: D4091-1

Job No: 192787

Serial No/Batch: S174252

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/23/19

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
130 QC 6	50 pcs	4/26/19	0.00	0.00	QC 6 - 9	MAY 02 2019 DAS 40 9-89
					QC 6 - 68	
160 QC 3	50 pcs	4/26/19	0.00	0.00	QC 6 - 61	
					QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	MAY 02 2019 DAS 40 9-89
					QC 3 - 19	
170 Packaging 3-1 - Stock - B4B	50 pcs	4/26/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
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					Packaging 3 - 18 - B4B	
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					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	51525 MAY 06 2019
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	

					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	50 pcs	4/26/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	DAS
					QC 21 - SA - 53	21

Part Op **100** - (Purchasing) ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005
 Descriptions: **110** - (Receive & Inspect for Damage & Mat'l Certs)
130 - (QC6- All purchased or subcontracted products)
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

9-60 MAY 07 2019

MAY 07 2019

PO043091

x 50

plus

APR 03 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	6.2550 ft (.1251 ea)	100-Purchasing	5174251
D4091-1P	Lug	50 pcs (1 ea)	100-Purchasing	5174249

Job Allocations

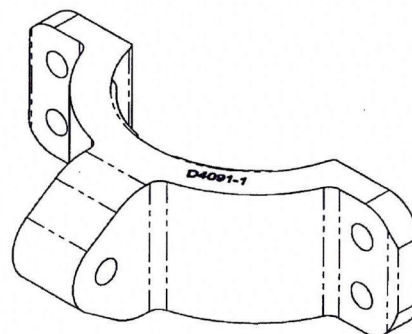
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2423	6	420	0
	D4091-1P	50	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	1.380Inches ± 0.030	1.410 1.350		
2	Mounting Lug	4.450Inches ± 0.030	4.480 4.420		
3	Mounting Lug	0.270Inches ± 0.030	0.300 0.240	Reference	
4	Mounting Lug	1.910Inches ± 0.030	1.940 1.880		
5	Mounting Lug	0.690Inches ± 0.030	0.720 0.660		
6	Mounting Lug	0.293Inches ± 0.010	0.303 0.283		
7	Mounting Lug	0.735Inches ± 0.010	0.745 0.725	Reference	
8	Mounting Lug	0.375Inches ± 0.010	0.385 0.365		
9	Mounting Lug	3.700Inches ± 0.010	3.710 3.690		
10	Mounting Lug	0.625Inches ± 0.010	0.635 0.615		
11	Mounting Lug	0.375Inches ± 0.010	0.385 0.365		
12	Mounting Lug	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
13	Mounting Lug	0.400Inches ± 0.030	0.430 0.370	Radius	
14	Mounting Lug	2.310Inches ± 0.010	2.320 2.300	Reference	

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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED
 SUBJECT TO A
 WITHOUT
 WORK
 NO. 192 787 MW
 19-04-02



D4091-1 MOUNTING LUG

RELEASED
 2010-04-28

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: 0.31 lbs

A		NEW ISSUE		CP	10.03.29
REV.		DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	CP			SHEET 1 OF 2	
CHECKED		DRAWING NO. D4091		SCALE	
MFG. APPR.		TITLE MOUNTING LUG		NTS	
APPROVED		DATE 10.03.29			
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043091



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043091

PO Date: 4/3/19

Due Date: 4/26/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192861	D3910-3P			Crosstube Lug : Various STC's As Per Dwg D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	4/19/19	15 pcs	0 pcs	15 pcs	\$17.40/pcs	\$261.00
						15 x		APR 23 2019					
2	192787	D4091-1P			Lug : Various STC's As Per Dwg D4091 Rev. A Alodine and Paint as Per QSI 005	Firmed	-	4/26/19	50 pcs	0 pcs	50 pcs	\$17.40/pcs	\$870.00
						50 x		APR 23 2019					
3	192785	D3910-1P			Crosstube Lug : Various STC's As Per Dwg D3910 Rev. E Alodine and Paint as pe QSI 005	Firmed	-	4/26/19	60 pcs	0 pcs	60 pcs	\$17.40/pcs	\$1,044.00
						60 x		APR 23 2019					
4	192917	D3910-3P			Crosstube Lug : Various STC's As Per Dwg D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	4/26/19	15 pcs	0 pcs	15 pcs	\$17.40/pcs	\$261.00
Grand Total:													\$2,436.00

DAS
40
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO043091



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

A handwritten signature in black ink, likely belonging to Patrick Lussier, located to the right of the Procurement Quality Clauses list.

Plex 4/4/19 9:38 AM dart.Lussier.Patrick

**METAL TECHNOLOGY INC.****www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956**

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24955
Shipment Date: 04-Apr-2019
Ship Via: Pick up at METEC
Order Number: 3702
Order Date: 04/03/19

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO043091 ✓
Terms: Net 60 Days

----- Quantity -----									Job
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>		<u>Revision</u>	<u>Number</u>
1	15	15 ✓	0	0	EA	D3910-3P Crosstube Lug alodined and painted as per QSI005		E	3702-01
2	50	50 ✓	0	0	EA	D4091-1P Lug alodined and painted as per QSI 005		A	3702-02
3	60	60 ✓	0	0	EA	D3910-1P Crosstube Lug, alodined and painted as per QSI 005		E	3702-03

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
60	D3910-1	Cross Tube Lug	E	B101186	014668-1	43091
15	D3910-3	Cross Tube Lug	E	B101186	014832-1	43091
49	D4091-1	Mounting Lug	A	B101186	016012-1	43091
1	D4091-	Mounting Lug	A	B101186	016012-2	43091

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9-89

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, April 4, 2019